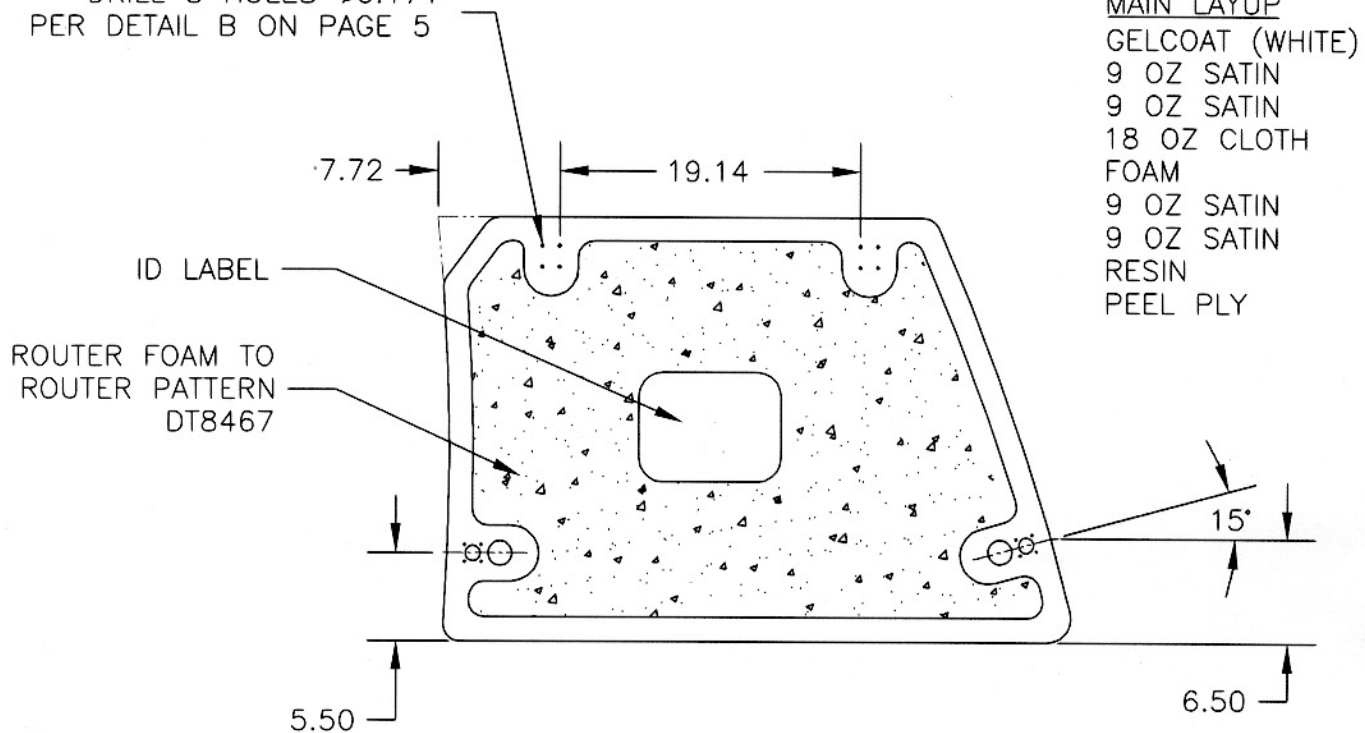


**DART**

DESIGN JB	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2176	REV. B SHEET 1 OF 5
DATE 00.05.05	TITLE SPACEPOD DOOR		SCALE NTS
A	93.08.20	NEW ISSUE	
B	00.05.05	REDRAWN; ADD D2176-5/-6	
B1	RF 00.11.09	ADD FOAM PART #5 D2176-101/-102	

**RELEASED**  
00.06.29 [Signature]DRILL 8 HOLES  $\phi 0.171$   
PER DETAIL B ON PAGE 5D2176-1(OBSOLETE PART. SHOWN FOR  
REFERENCE ONLY. REPLACED BY D2176-5)**MATERIALS:**

RESIN: DERAKANE 470-36/411/510A40

FOAM: A500 CORE-CELL PL 12 MM OR DIVINYLCELL OR AIREX

FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")

18 OZ ROVING "E" GLASS ("18 OZ CLOTH")

LAMINATE PER DART QSI 006 4.0  
LAMINATION SCHEDULE PER THIS DRAWING**Copyright © 1993 by DART AEROSPACE LTD**

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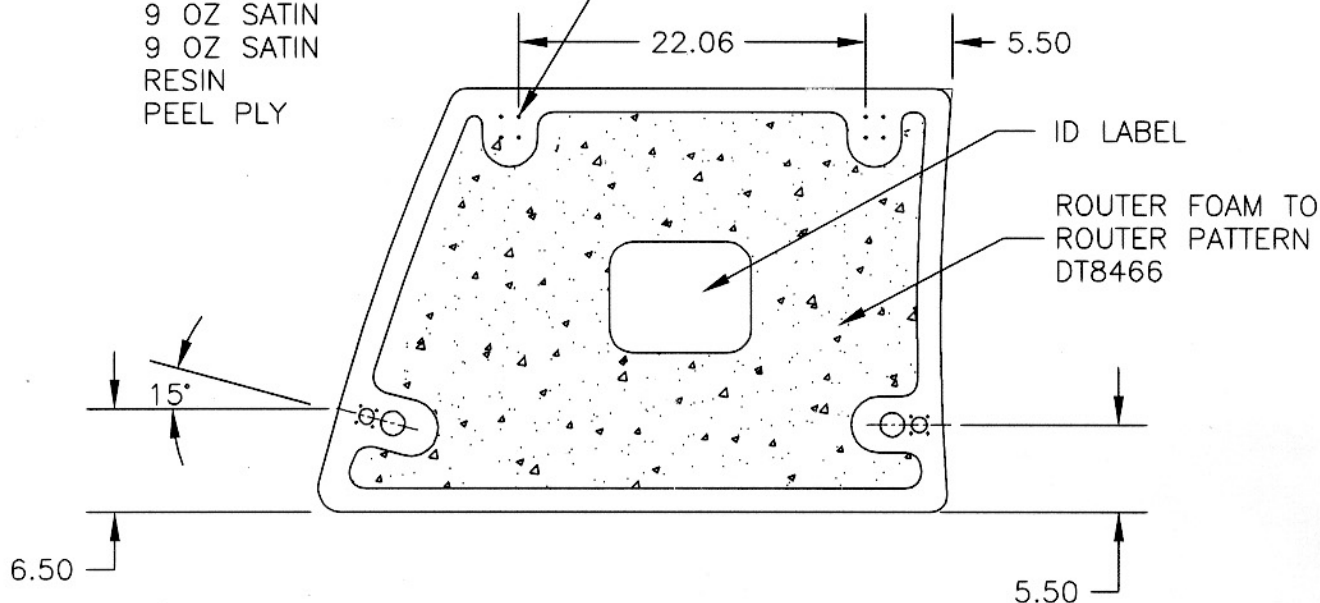
**DART**

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2176	REV. B SHEET 2 OF 5
DATE 00.05.05	TITLE SPACEPOD DOOR		SCALE NTS

**RELEASED**  
00-06-29 #**MAIN LAYUP**

GELCOAT (WHITE)  
9 OZ SATIN  
9 OZ SATIN  
18 OZ CLOTH  
FOAM  
9 OZ SATIN  
9 OZ SATIN  
RESIN  
PEEL PLY

DRILL 8 HOLES  $\phi 0.171$   
PER DETAIL B ON PAGE 5

**D2176-2**

(OBSOLETE PART. SHOWN FOR  
REFERENCE ONLY. REPLACED BY D2176-6)

**MATERIALS:**

RESIN: DERAKANE 470-36/411/510A40  
FOAM: A500 CORE-CELL PL 12 MM OR DIVINYCELL OR AIREX  
FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")  
18 OZ ROVING "E" GLASS ("18 OZ CLOTH")

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DATE 00.05.05	TITLE SPACEPOD DOOR		SCALE NTS

**RELEASED**  
00.06.24 [Signature]**MAIN LAYUP****PRIMER**

9 OZ SATIN (9 SQ FEET)

9 OZ SATIN (9 SQ FEET)

18 OZ CLOTH (9 SQ FEET)

**FOAM**

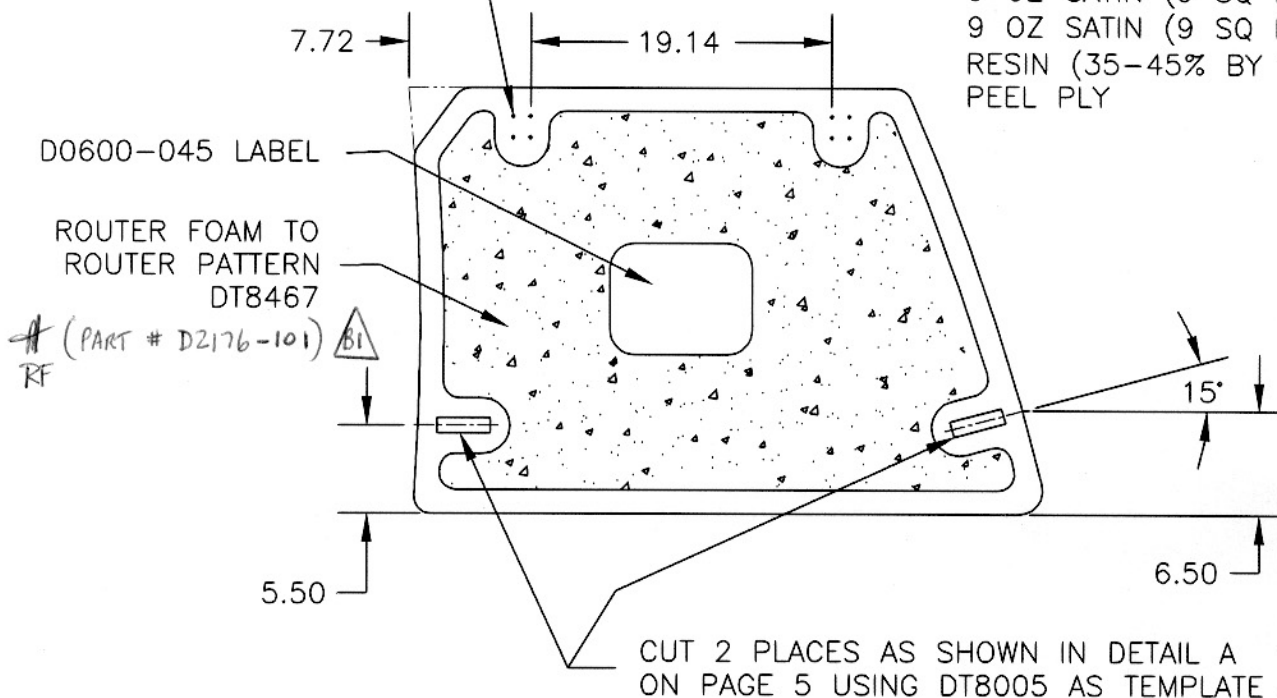
9 OZ SATIN (9 SQ FEET)

9 OZ SATIN (9 SQ FEET)

RESIN (35-45% BY WEIGHT)

**PEEL PLY**

DRILL 8 HOLES  $\phi 0.171$   
PER SCRIBE LINES OF  
MOLD DT8005 (REFER  
TO DETAIL B ON PAGE 5)

**D2176-5**

USE MOLD DT8005 FOR DOOR LAYUP

**MATERIALS:**RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/  
411/510A40

FOAM: A500 CORE-CELL PL 12 MM OR DIVINYCELL OR AIREX

FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")

18 OZ ROVING "E" GLASS ("18 OZ CLOTH")

PRIMER: EPOXY PRIMER WHITE 4500-PB-40 (2 PART PRIMER)

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DATE 00.05.05	TITLE SPACEPOD DOOR		SCALE NTS

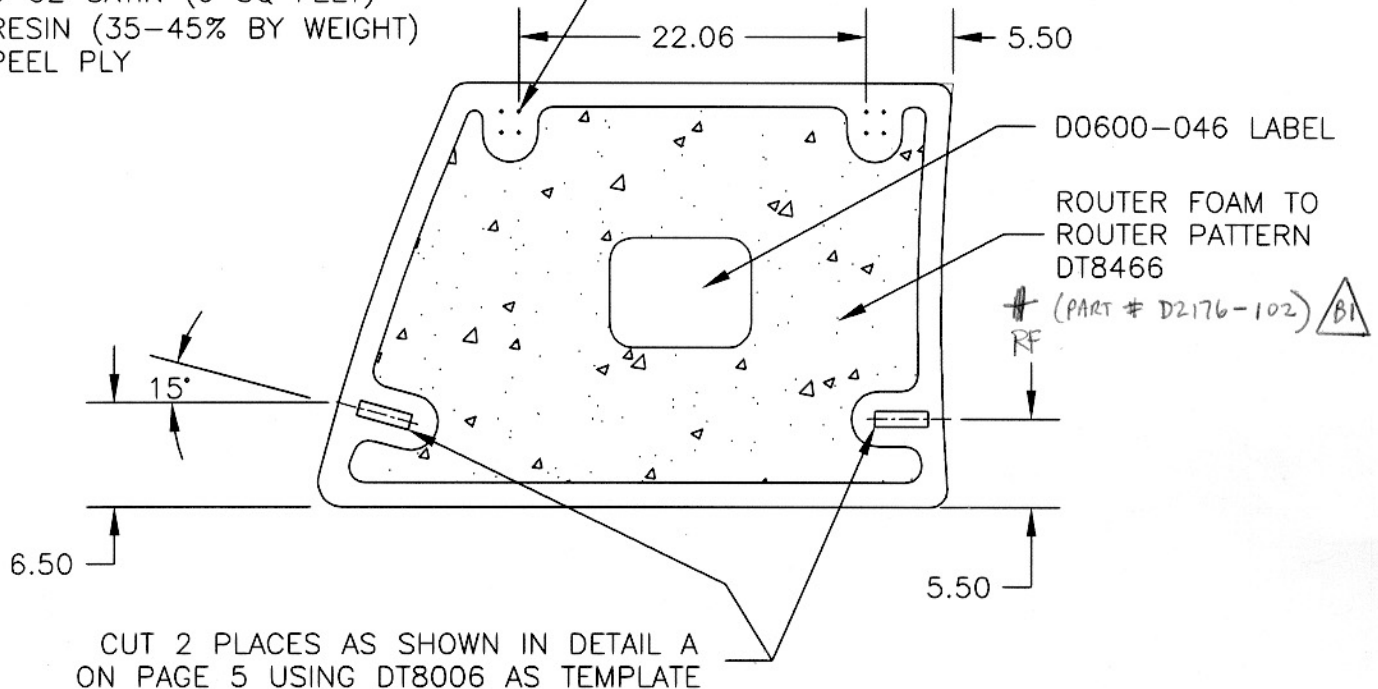
RELEASED  
00-06-29 *[Signature]*

#### MAIN LAYUP

##### PRIMER

9 OZ SATIN (9 SQ FEET)  
9 OZ SATIN (9 SQ FEET)  
18 OZ CLOTH (9 SQ FEET)  
FOAM  
9 OZ SATIN (9 SQ FEET)  
9 OZ SATIN (9 SQ FEET)  
RESIN (35-45% BY WEIGHT)  
PEEL PLY

DRILL 8 HOLES  $\phi 0.171$   
PER SCRIBE LINES OF  
MOLD DT8006 (REFER  
TO DETAIL B ON PAGE 5)



D2176-6

USE MOLD DT8006 FOR DOOR LAYUP

#### MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/  
411/510A40

FOAM: A500 CORE-CELL PL 12 MM OR DIVINYCELL OR AIREX

FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")

18 OZ ROVING "E" GLASS ("18 OZ CLOTH")

PRIMER: EPOXY PRIMER WHITE 4500-PB-40 (2 PART PRIMER)

LAMINATE PER DART QSI 006 4.0

LAMINATION SCHEDULE PER THIS DRAWING

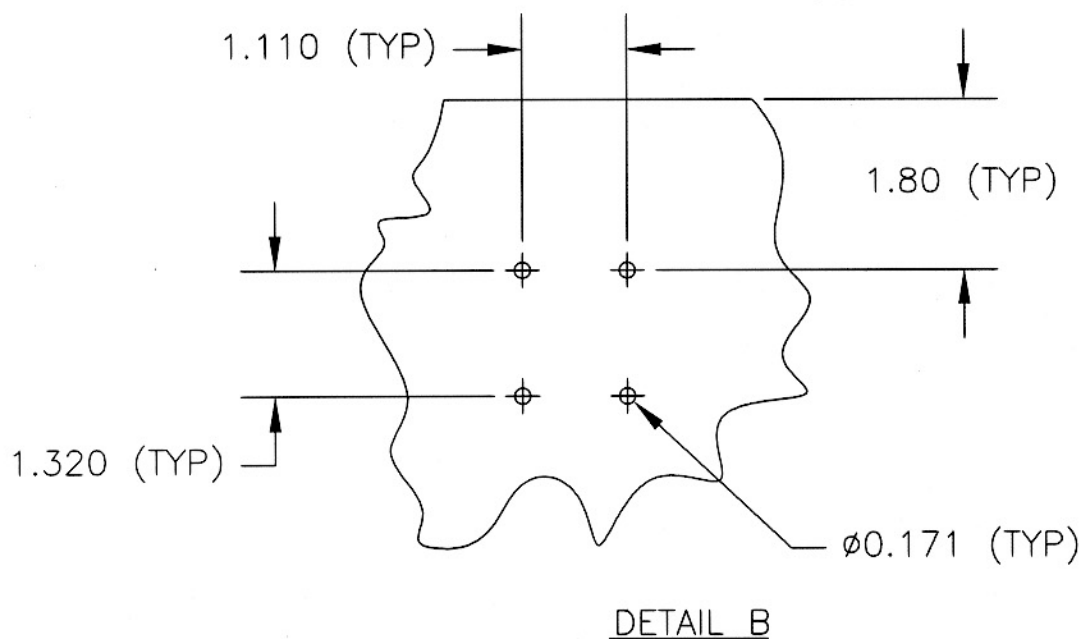
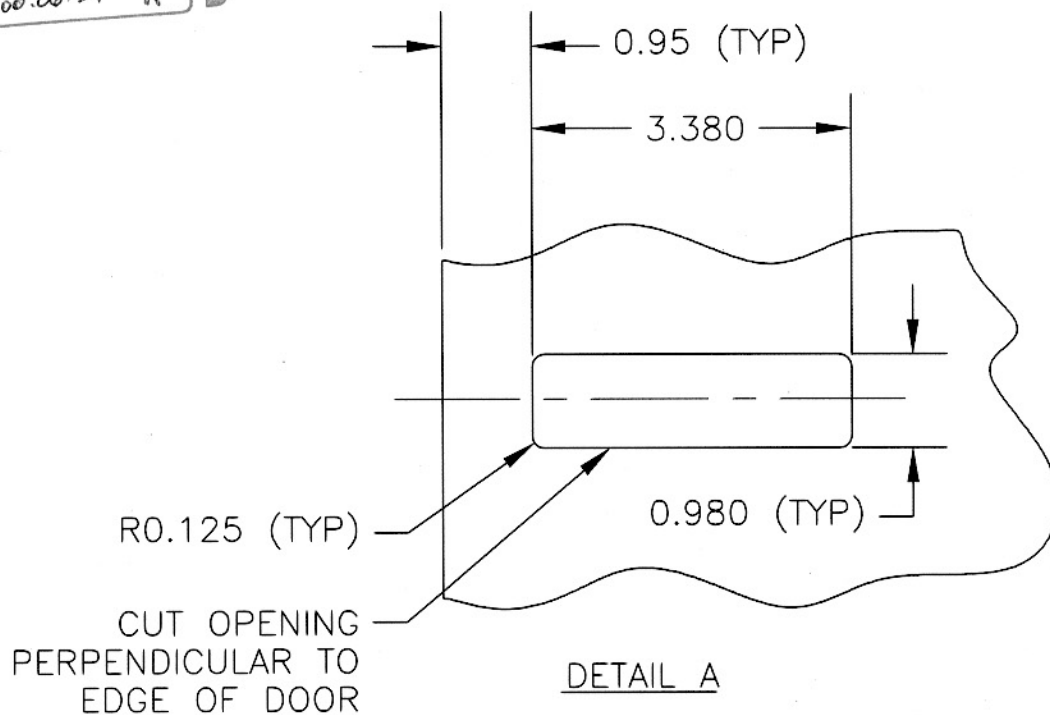
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DATE 00.05.05		TITLE SPACEPOD DOOR	SCALE NTS

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